

Date: Tuesday, 11/21/2006 10:44:52 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET  
 Job Number : 29553  
 Estimate Number : 10710  
 P.O. Number : N/A Part Number : D32111  
 This Issue : 11/21/2006 S.O. No. : N/A Drawing Number : D3211 REV A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A1  
 Previous Run : 29014 Material : N/A  
 Due Date : 11/23/2006 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 05-11-17 JLM  
 Est Rev:B Now on Waterjet 06-10-24 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 1.4753 sf(s)/Unit Total : 5.9010 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)Identify as D3211-1 M101022

Batch: ~~M18481~~ M18481 M 06 11 21

(4)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3211

→ \*\*\* ATTN: NO HOLES \*\*\*\* ←

M 06 11 21

(4)

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



M 06 11 21



(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

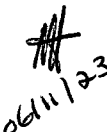

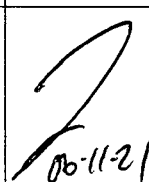
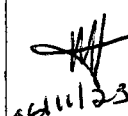
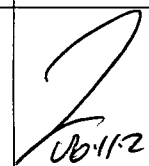
12/22/22

(4)

PRO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/21	2.0	• OBO material was used. Parts were cut at the same time as the D3210-1 doublers. Human error.	 06/11/23	Remind employee to verify material thickness before starting. Scraps, destroy the parts and replace.	 06/11/21	 06/11/21	 06/11/23	 06/11/21

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29553

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SB 06/11/22 (4)

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 06/11/22 (4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/22 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

amf 06/11/22 x4

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 11 22 (4)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 11 22 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

06/11/23 (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/23 (4)

Job Completion



06/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

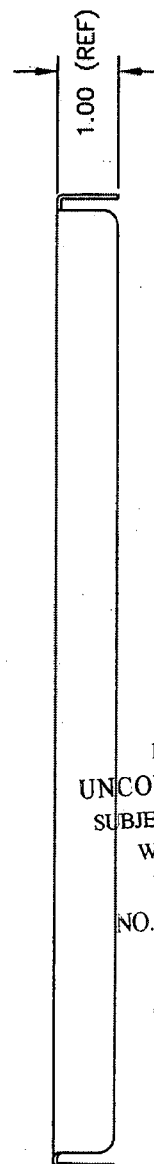
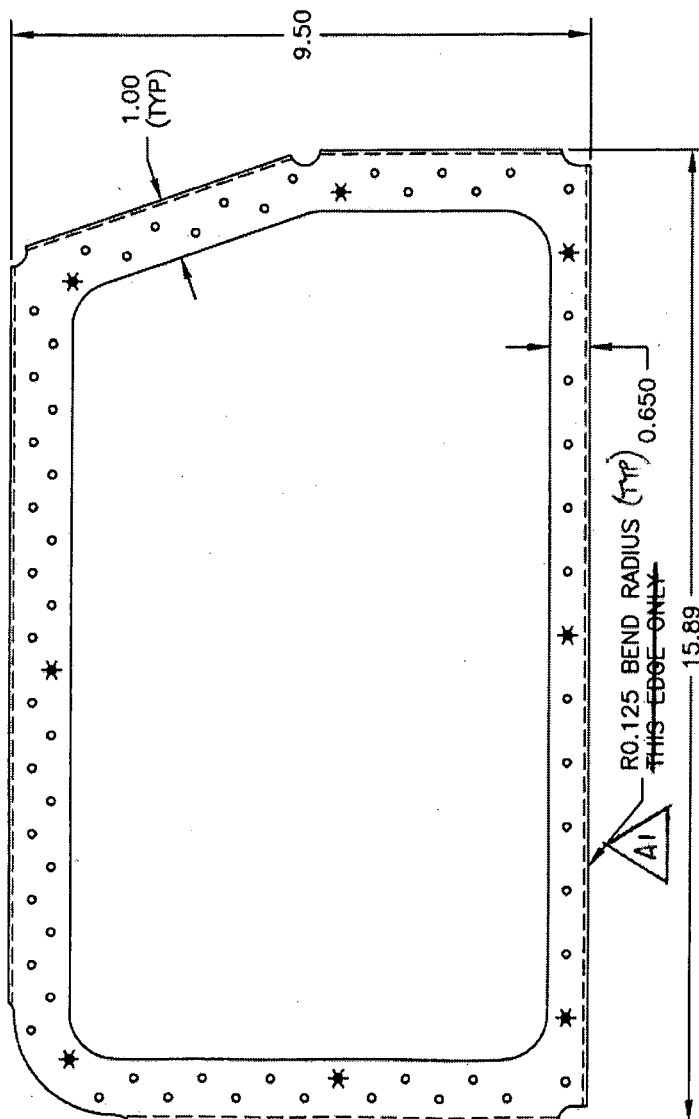




DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 1 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3
A	03.09.03	NEW ISSUE	
A1	<i>[Signature]</i> 03.12.05	CHANGE ALL BEND RADII TO R0.125	

RELEASED  
03.09.15

D3211-1 BRACKET  
MACHINE PER DRAWING FILE "D3211-A2.DWG"  
CHECK PER TEMPLATE D3211-1T1  
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
USE MINIMUM BEND RADIUS OF ~~0.188"~~ **0.125"** EXCEPT WHERE INDICATED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



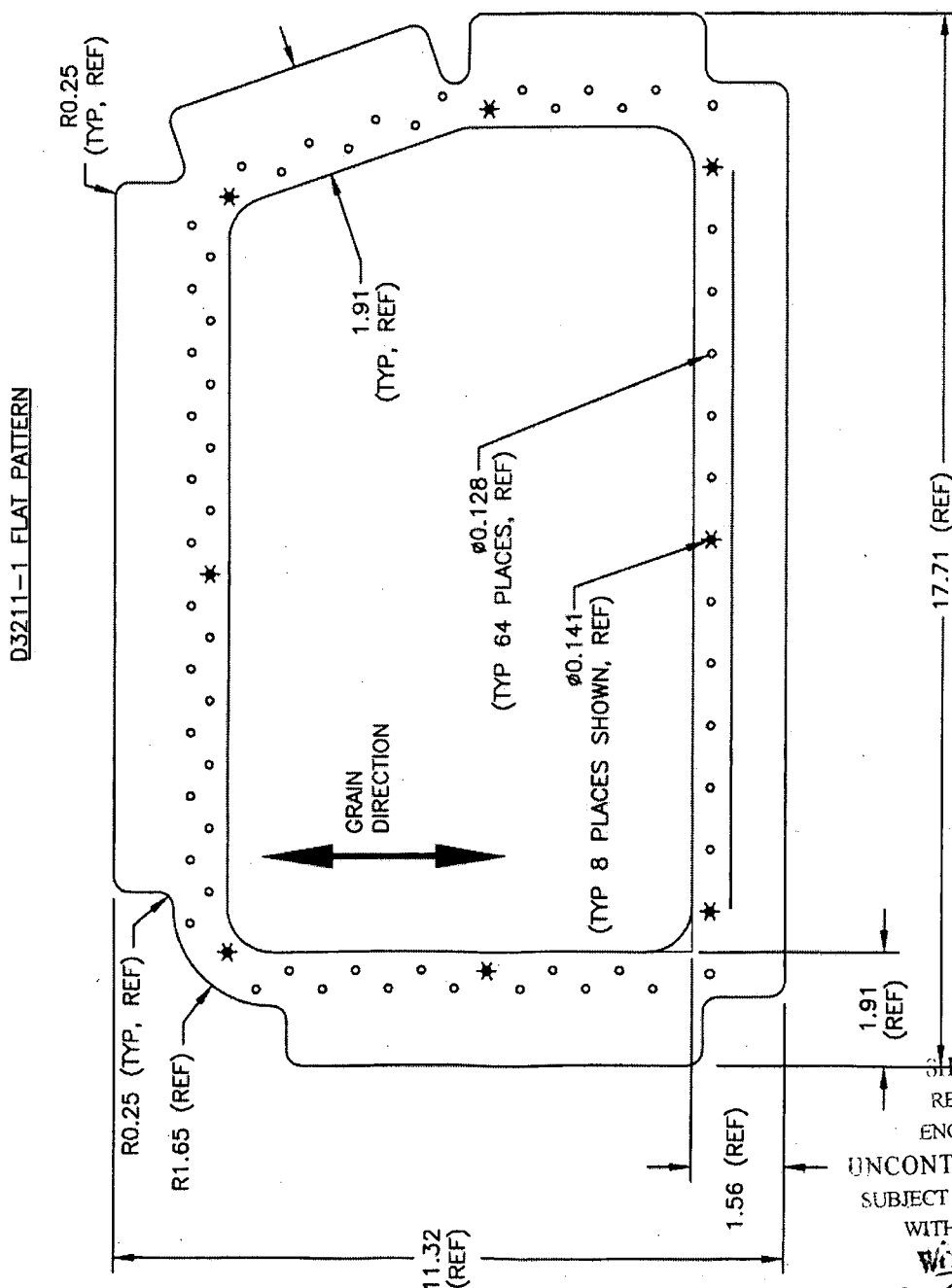
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